

Work Order ID 77740

Tuesday, December 20, 2011 9:02:16 AM

77740

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Item ID: D3591-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bushing

Start Date: 12/20/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/20/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: CMKDate: 11-12-20

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3591

Rev B

100

0.00

100

Hardinge

CONVENTIONAL LATHE

Memo

0.00

Hardinge CNC Lathe Small

1-Turn as per dwg D35912-Deburr

110

0.00

110

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

120

0.00

120

QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3591-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bushing
 Start Date: 12/20/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 12/20/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>UP</i>	0.00							
130									
Packaging	Memo <i>PAB</i>	0.00							<i>11/12/20</i> <i>(4)</i>
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									<i>11/12/20</i> <i>(J)</i>
QC	Memo	0.00							
Quality Control									<i>mf</i> <i>11-12-20</i>

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Picklist Print

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Work Order ID: 77740

Parent Item: D3591-1

Parent Item Name: Bushing

Start Date: 12/20/2011

Required Date: 12/20/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A 07.02.01 new issue EC
IPP Rev:B 08-09-10 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035 304 RD Tube .500 x .035W		Purchased	No			100	f	119.9053	0.35	1.4736842			

Location

Loc Qty

Loc Code

MAT017

119.9052723

115535

0.913

116720

1.66068

117598

7.6415923

119160

12.09

119644

97.6

1.5

RD 11/12/20

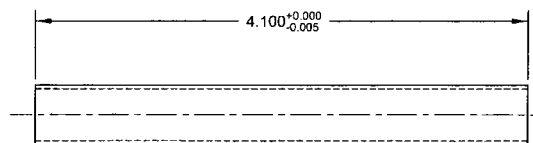
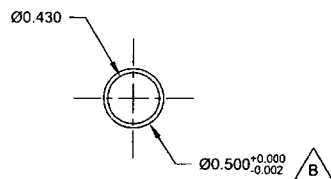
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



77740

D3591-1 BUSHING

RELEASED
08-09-03-111

NOTES:

- 1) MATERIAL: AISI 304/316 SS, Ø0.500, 0.035 WALL SEAMLESS ROUND TUBING
REF. DART SPEC M304TR0.500W.035
OR: AISI 303/304/316 SS, ROUND BAR
REF DART SPEC M303R/M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

B	DRAWING UPDATED TO "B" SIZE FORMAT AND CURRENT STANDARDS. ZN C6 TOLERANCE WAS -0.005. MATERIAL UPDATED TO ALLOW PART TO BE MACHINED TO MAINTAIN TOLERANCE. (SEE NCR 08-074 FOR FURTHER DETAILS.)	AJS	08.08.25
A	NEW ISSUE	PH	07.01.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. 1 OF 1
MFG. APPR.		D3591	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		BUSHING	NTS
DATE	08.08.25	COPYRIGHT © 2007 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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